

NEW PATENT APPLICATION COVER PAGE

**TITLE: IMINO-AMIDE CATALYST COMPOSITIONS FOR THE
POLYMERIZATION OF OLEFINS**

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IMINO-AMIDE CATALYST COMPOSITIONS **FOR THE POLYMERIZATION OF OLEFINS**

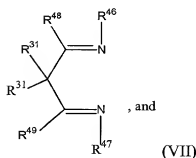
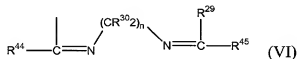
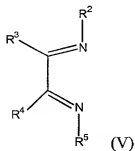
FIELD OF THE INVENTION

[0001] The present invention relates to a family of novel imino-amide catalyst precursors and catalysts useful for the polymerization of olefins, such as ethylene, higher alpha-olefins, dienes, and mixtures thereof.

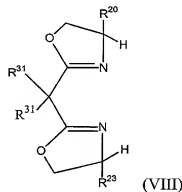
BACKGROUND OF THE INVENTION

[0002] A variety of metallocenes and other single site-like catalysts have been developed to prepare olefin polymers. Metallocenes are organometallic coordination complexes containing one or more pi-bonded moieties (i.e., cyclopentadienyl groups) in association with a metal atom. Catalyst compositions containing metallocenes and other single site-like catalysts are highly useful for the preparation of polyolefins, producing relatively homogeneous copolymers at excellent polymerization rates while allowing one to closely tailor the final properties of the polymer as desired.

[0003] Recently, work relating to certain nitrogen-containing, single site-like catalyst precursors has been published. For example, PCT application No. WO 96/23101 relates to di(imine) metal complexes that are transition metal complexes of bidentate ligands selected from the group consisting of:



, and



wherein said transition metal is selected from the group consisting of Ti, Zr, Sc, V, Cr, a rare earth metal, Fe, Co, Ni, and Pd;

R^2 and R^5 are each independently hydrocarbyl or substituted hydrocarbyl, provided that the carbon atom bound to the imino nitrogen atom has at least two carbon atoms bound to it;

R^3 and R^4 are each independently, hydrogen, hydrocarbyl, substituted hydrocarbyl, or R^3 and R^4 taken together are hydrocarbylene or substituted hydrocarbylene to form a carbocyclic ring;

R^{44} is a hydrocarbyl or substituted hydrocarbyl, and R^{28} is hydrogen, hydrocarbyl or substituted hydrocarbyl or R^{44} and R^{28} taken together form a ring;

R^{45} is a hydrocarbyl or substituted hydrocarbyl, and R^{29} is hydrogen, hydrocarbyl or substituted hydrocarbyl or R^{45} and R^{29} taken together form a ring;

each R^{30} is independently hydrogen, hydrocarbyl or substituted hydrocarbyl, or two of R^{30} taken together form a ring;

each R^{31} is independently hydrogen, hydrocarbyl or substituted hydrocarbyl;

R^{46} and R^{47} are each independently hydrocarbyl or substituted hydrocarbyl, provided that the carbon atom bound to the imino nitrogen atom has at least two carbon atoms bound to it;

R^{48} and R^{49} are each independently hydrogen, hydrocarbyl, or substituted hydrocarbyl;

R^{20} and R^{23} are each independently hydrocarbyl, or substituted hydrocarbyl;

R^{21} and R^{22} are independently hydrogen, hydrocarbyl, or substituted hydrocarbyl; and n is 2 or 3;

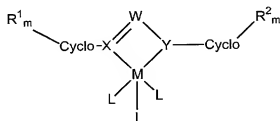
and provided that:

the transition metal also has bonded to it a ligand that may be displaced by or added to the olefin monomer being polymerized; and

when the transition metal is Pd, said bidentate ligand is (V), (VII) or (VIII).

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[0004] Also, U.S. Patent No. 6,096,676, which is incorporated herein by reference, teaches a catalyst precursor having the formula:



wherein M is a Group IVB metal;

each L is a monovalent, bivalent, or trivalent anion;

X and Y are each heteroatoms, such as nitrogen;

each Cyclo is a cyclic moiety;

each R¹ is a group containing 1 to 50 atoms selected from the group consisting of hydrogen and Group IIIA to Group VIIA elements, and two or more adjacent R¹ groups may be joined to form a cyclic moiety;

each R² is a group containing 1 to 50 atoms selected from the group consisting of hydrogen and Group IIIA to Group VIIA elements and two or more adjacent R² groups may be joined to form a cyclic moiety;

W is a bridging group; and

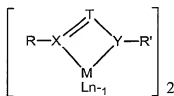
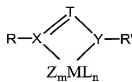
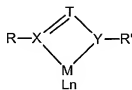
each m is independently an integer from 0 to 5.

Also taught is a catalyst composition comprising this catalyst precursor and an activating co-catalyst, as well as a process for the polymerization of olefins using this catalyst composition.

[0005] Although there are a variety of single site catalysts taught in the art, some of which are commercially available, there still exist a need for improved catalysts and catalyst precursors that are capable of producing polyolefins having predetermined properties.

SUMMARY OF THE INVENTION

[0006] In accordance with the present invention, there is provided catalyst precursors of the formulae:



wherein T is a bridging group containing 2 or more bridging atoms;

M is a metallic element selected from Groups 1 to 15, and the lanthanide series of the Periodic Table of the Elements;

Z is a coordination ligand;

each L is a monovalent, bivalent, or trivalent anionic ligand;

n is an integer from 1 to 6;

m is an integer from 1 to 3;

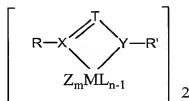
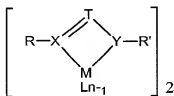
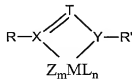
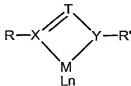
X and Y are heteroatoms each independently selected from nitrogen sulfur, oxygen and phosphorus;

R is a non-bulky substituent that has relatively low steric hindrance with respect to X and is preferably a straight or branched chain alkyl group; and

R' is a bulky substituent with respect to Y and is selected from the group consisting of alkyl, alkenyl, cycloalkyl, heterocyclic (both heteroalkyl and heteroaryl), alkylaryl, arylalkyl, and polymeric groups.

DETAILED DESCRIPTION OF THE INVENTION

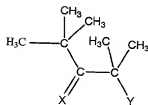
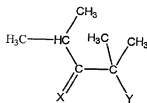
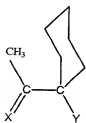
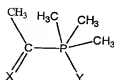
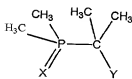
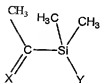
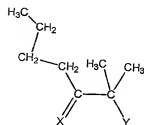
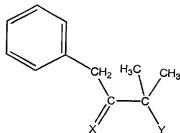
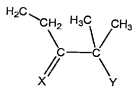
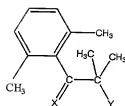
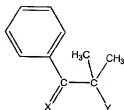
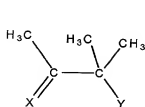
[0007] The catalyst precursors of the present invention will have the formula:



wherein T is a bridging group containing 2 or more bridging atoms, wherein at least one of the bridging atoms is a Group 14 element, preferably a carbon atom, and wherein T can also contain one or more elements selected from Groups 13 to 16 of the Periodic Table of the Elements. It is preferred that all of the bridging atoms be carbon atoms. It is also preferred that there be only 2 or 3 bridging atoms. The total number of non-hydrogen atoms can be from about 2 to 50, preferably from about 2 to 20, and more preferably less than about 10.

[0008] The most preferred T groups are those wherein there is a dimethyl grouping adjacent to Y.

[0009] Preferred bridging groups include:



[0010] The X and Y substituents are included for convenience to show where the bridging groups would bridge.

[0011] M is a metallic element selected from Groups 1 to 15, preferably from Groups 3 to 13, more preferably from the transition metals of Groups 3 to 7, and the Lanthanide series of the Periodic Table of the Elements. The Periodic Table of the Elements referred to herein is that table that appears in the inside front cover of Lange's Handbook of Chemistry, 15th Edition, 1999, McGraw Hill Handbooks.

[0012] Z is a coordination ligand. Preferred coordination ligands include triphenylphosphine, tris(C₁-C₆ alkyl) phosphine, tricycloalkyl phosphine, diphenyl alkyl phosphine, dialkyl phenyl phosphine, trialkylamine, arylamine such as pyridine, a substituted or unsubstituted C₂ to C₂₀ alkene (e.g. ethylene, propylene, butene, hexene, octane, decene, dodecene, allyl, and the like) in which the substituent is a halogen atom (preferably chloro), an ester group, a C₁ to C₄ alkoxy group, an amine group (-NR₂ where each R individually is a C₁ to C₃ alkyl), carboxylic acid, di(C₁ to C₄) alkyl ether, tetrahydrofuran (THF), a nitrile such as acetonitrile, an η⁴-diene, and the like.

[0013] m is an integer from 1 to 3.

[0014] Each L is a monovalent, bivalent, or trivalent anionic ligand, preferably containing from about 1 to 50 non-hydrogen atoms, more preferably from about 1 to 20 non-hydrogen atoms and is independently selected from the group consisting of halogen containing groups; hydrogen; alkyl; aryl; alkenyl; alkylaryl; arylalkyl; hydrocarboxy; amides, phosphides; sulfides; silyalkyls; diketones; borohydrides; and carboxylates. More preferred are alkyl, arylalkyl, and halogen containing groups.

[0015] n is an integer from 1 to 6, preferably from 1 to 4, more preferably from 1 to 3.

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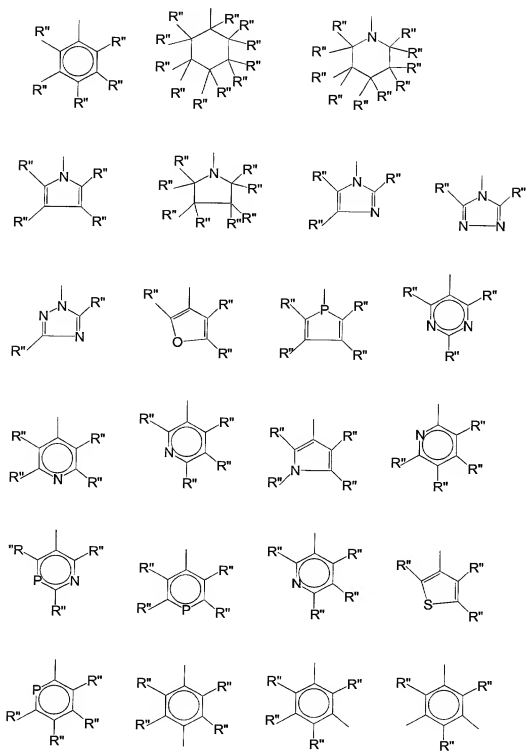
[0016] X and Y are each independently selected from nitrogen, sulfur, oxygen and phosphorus; more preferably both X and Y are nitrogen.

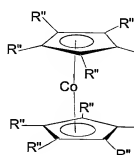
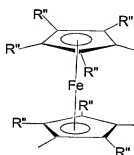
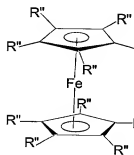
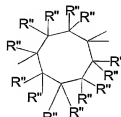
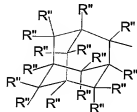
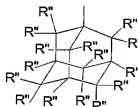
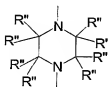
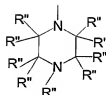
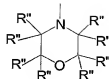
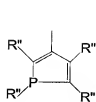
[0017] R is a non-bulky substituent, preferably a non-cyclic substituent, that has relatively low steric hindrance with respect to X. Non-limiting examples of non-bulky substituents include C₁ to C₃₀ straight and branched chain alkyl groups, preferably a C₁ to C₂₀ straight chain group; and more preferably an n-octyl group. If the non-bulky group is branched, the branch point must be at least 3 atoms removed from X.

[0018] R' is a bulky substituent. That is, a sterically hindering group with respect to Y. R' can be selected from alkyl (preferably branched), alkenyl (preferably branched), cycloalkyl, heterocyclic (both heteroalkyl and heteroaryl), alkylaryl, arylalkyl, and polymeric, including inorganics such as the P-N ring structures set forth below and inorganic-organic hybrid structures, such as those set forth below. It is preferred that the R' substituent contain from about 3 to 50, more preferably from about 3 to 30, and most preferably from about 4 to 20 non-hydrogen atoms. Also, one or more of the carbon or hydrogen positions can be substituted with an element other than carbon and hydrogen, preferably an element selected from Groups 14 to 17, more preferably a Group 14 element such as silicon, a Group 15 element such as nitrogen, a Group 16 element such as oxygen, or a Group 17 halogen.

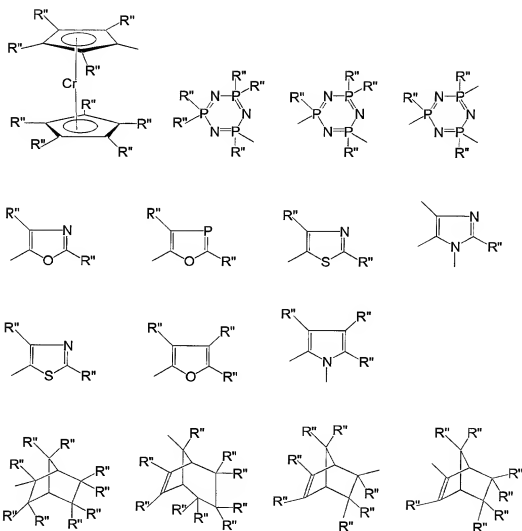
[0019] In a preferred embodiment two or three of T, R and R' are co-joined to form a ring structure.

[0020] Non-limiting examples of R' include:





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[0021] It is preferred that the total number of non-hydrogen atoms for the sum of all R'' groups be up to about 40 atoms. It is also preferred that the R'' be selected from hydrogen, halogen, halogen-containing groups, and C₁ to C₃₀ alkyl, aryl, alkylaryl, arylalkyl, cycloalkyl, and heterocyclic groups as defined above; more preferably R'' is selected from C₂ to C₂₀ alkyl, aryl, alkylaryl, cycloalkyl, or heterocyclic; and most preferably R'' is a C₅ to C₂₀ arylalkyl group.

[0022] The catalyst precursors can be prepared by any suitable synthesis method and the method of synthesis is not critical to the present invention. One useful

method of preparing the catalyst precursors of the present invention is by reacting a suitable metal compound, preferably one having a displaceable anionic ligand, with a heteroatom-containing ligand of this invention. Non-limiting examples of suitable metal compounds include organometallics, metal halides, sulfonates, carboxylates, phosphates, organoborates (including fluoro-containing and other subclasses), acetoneacetates, sulfides, sulfates, tetrafluoroborates, nitrates, perchlorates, phenoxides, alkoxides, silicates, arsenates, borohydrides, naphthenates, cyclooctadienes, diene conjugated complexes, thiocyanates, cyanates, and the metal cyanides. Preferred are the organometallics and the metal halides. More preferred are the organometallics.

[0023] As previously mentioned, the metal of the organometal compound is selected from Groups 1 to 16. It is preferred that it be a transition metal selected from the Group 3 to Group 13 elements and Lanthanide series elements. It is more preferred that the metal be selected from the Group 3 to Group 7 elements. The groups referred to are from the Periodic Table of the Elements. It is most preferred that the metal be a Group 4 metal, more particularly preferred is zirconium and hafnium, and most particularly zirconium.

[0024] The transition metal compound can, for example, be a metal hydrocarbyl such as: a metal alkyl, a metal aryl, a metal arylalkyl, a metal silylalkyl, a metal diene, a metal amide; or a metal phosphide. Preferably, the transition metal compound is a zirconium or hafnium hydrocarbyl. More preferably, the transition metal compound is a zirconium arylalkyl. Most preferably, the transition metal compound is tetrabenzylzirconium. It is also preferred that the intermediate complexes formed by the present invention correspond to the formula: $MX_2D(L')_2$ wherein M is hafnium or zirconium, X is halide, D is 1,4-diphenyl-1-3-butadiene, and L' is trimethylphosphine, triethylphosphine, tri-n-propylphosphine, or tri-n-butylphosphine. More preferred intermediate complexes are those wherein X is chloride or bromide.

[0025] Non-limiting examples of useful and preferred transition metal compounds include:

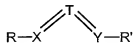
(i) tetramethylzirconium, tetraethylzirconium, zirconiumdichloride (η^4 - 1,4-diphenyl-1,3-butadiene) bis (triethylphosphine), zirconiumdichloride (η^4 - 1,4-diphenyl-1,3-butadiene) bis (tri-n-propylphosphine), tetrakis[trimethylsilylmethyl]zirconium, tetrakis [dimethylamino]zirconium, dichlorodibenzylzirconium, chlorotribenzylzirconium, trichlorobenzylzirconium, bis[dimethylamino]bis[benzyl]zirconium, and tetrabenzylzirconium;

(ii) tetramethyltitanium, tetraethyltitanium, titaniumdichloride (η^4 - 1,4-diphenyl-1,3-butadiene) bis (triethylphosphine), titaniumdichloride (η^4 - 1,4-diphenyl-1,3-butadiene) bis (tri-n-propylphosphine), tetrakis[trimethylsilylmethyl]-titanium, tetrakis[dimethylamino]titanium, dichlorodibenzyltitanium, chlorotribenzyltitanium, trichlorobenzyltitanium, bis[dimethylamino]bis[benzyl]titanium, and tetrabenzyltitanium; and

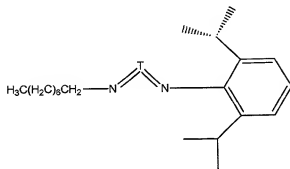
(iii) tetramethylhafnium, tetraethylhafnium, hafniumdichloride (η^4 - 1,4-diphenyl-1,3-butadiene) bis (triethylphosphine), hafniumdichloride (η^4 - 1,4-diphenyl-1,3-butadiene) bis (tri-n-propylphosphine) tetrakis[trimethylsilylmethyl]hafnium, tetrakis[dimethylamino]hafnium, dichlorodibenzylhafnium, chlorotribenzylhafnium, trichlorobenzylhafnium, bis[dimethylamino]bis[benzyl]hafnium, and tetrabenzylhafnium.

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[0026] One preferred heteroatom-containing ligand that meets the formula:

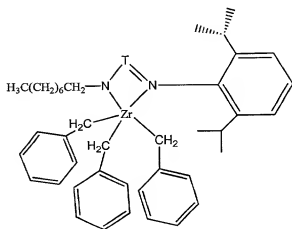


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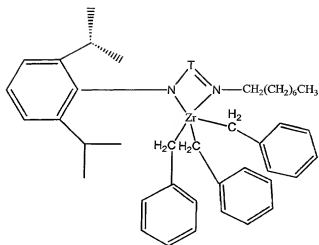
wherein X, Y, T, R, and R' have the meanings stated above.

[0027] When this ligand is reacted with tetrabenzylzirconium, the corresponding catalyst precursors obtained can be represented by:



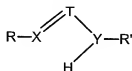
and

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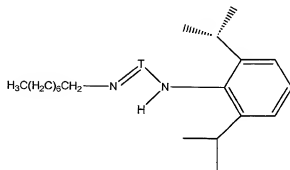


[0028] This second product, although obtained in lower yields than the first product, would be preferred for catalytic purposes.

[0029] Another preferred heteroatom-containing ligand that meets the formula:

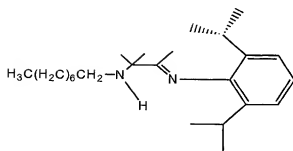
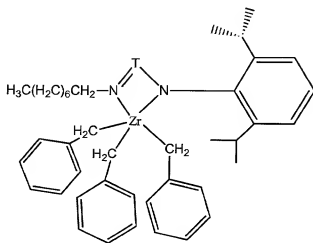


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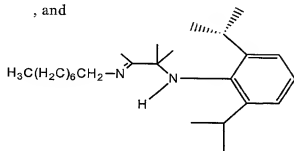


wherein X, Y, T, R, and R' have the meanings stated above.

[0030] When this ligand is reacted with tetrabenzylzirconium, the corresponding catalyst precursor will be yield a mixture of products represented by:

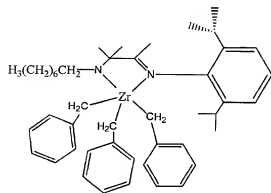


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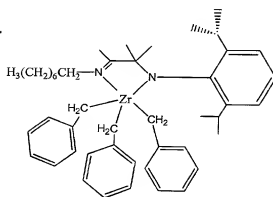


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[0031] When a mixture of these ligands is reacted with tetrabenzylzirconium, two catalyst precursor compounds are formed and are represented below along with the expected yields of each:



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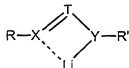


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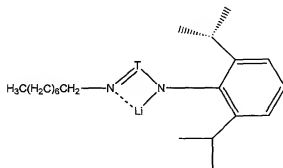
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[0032] Another preferred heteroatom-containing ligand that meets the formula:

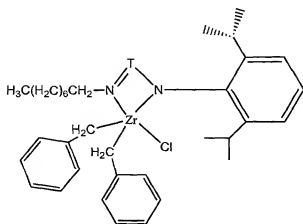


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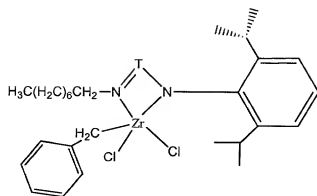
wherein X, Y, T, R, and R' have the meanings stated above.

[0033] When this ligand is reacted with dichlorodibenzylzirconium (best formed in situ by mixing zirconium tetrachloride and tetrabenzylzirconium is one possibility), several corresponding catalyst precursors are formed and can be represented by:

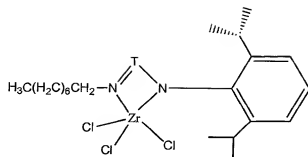


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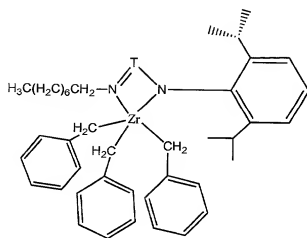
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and



and



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Activators and Activation Methods for Catalyst Compounds

[0034] The polymerization catalyst compounds of the invention are typically activated in various ways to yield compounds having a vacant coordination site that will coordinate, insert, and polymerize olefin(s). For the purposes of this patent specification and appended claims, the term "activator" is defined to be any compound which can activate any one of the catalyst compounds described above by converting the neutral catalyst compound to a catalytically active catalyst compound cation. Non-limiting activators, for example, include alumoxanes, aluminum alkyls, ionizing activators, which may be neutral or ionic, and conventional-type cocatalysts.

A. Alumoxane and Aluminum Alkyl Activators

[0035] In one embodiment, alumoxanes activators are utilized as an activator in the catalyst composition of the invention. Alumoxanes are generally oligomeric compounds containing -Al(R)-O- subunits, where R is an alkyl group. Examples of alumoxanes include methylalumoxane (MAO), modified methylalumoxane (MMAO), ethylalumoxane and isobutylalumoxane. Alumoxanes may be produced by the hydrolysis of the respective trialkylaluminum compound. MMAO may be produced by the hydrolysis of trimethylaluminum and a higher trialkylaluminum such as triisobutylaluminum. MMAO's are generally more soluble in aliphatic solvents and more stable during storage. There are a variety of methods for preparing alumoxane and modified alumoxanes, non-limiting examples of which are described in U.S. Patent No. 4,665,208, 4,952,540, 5,091,352, 5,206,199, 5,204,419, 4,874,734, 4,924,018, 4,908,463, 4,968,827, 5,308,815, 5,329,032, 5,248,801, 5,235,081, 5,157,137, 5,103,031, 5,391,793, 5,391,529, 5,693,838, 5,731,253, 5,731,451, 5,744,656, 5,847,177, 5,854,166, 5,856,256 and 5,939,346 and European publications EP-A-0 561 476, EP-B1-0 279 586, EP-A-0 594-218 and EP-B1-0 586 665, and PCT publications WO 94/10180 and WO 99/15534, all of which are herein fully incorporated by reference. A another alumoxane is a modified methyl alumoxane (MMAO) cocatalyst type 3A (commercially available from Akzo Chemicals, Inc.

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under the trade name Modified Methylalumoxane type 3A, covered under patent number US 5,041,584).

[0036] Aluminum Alkyl or organoaluminum compounds which may be utilized as activators include trimethylaluminum, triethylaluminum, triisobutylaluminum, tri-n-hexylaluminum, tri-n-octylaluminum and the like.

B. Ionizing Activators

[0037] It is within the scope of this invention to use an ionizing or stoichiometric activator, neutral or ionic, such as tri (n-butyl) ammonium tetrakis (pentafluorophenyl) boron, a tris(perfluorophenyl) boron metalloid precursor or a tris(perfluoronaphthyl) boron metalloid precursor, polyhalogenated heteroborane anions (WO 98/43983), boric acid (U.S. Patent No. 5,942,459) or combination thereof. It is also within the scope of this invention to use neutral or ionic activators alone or in combination with alumoxane or modified alumoxane activators.

[0038] Examples of neutral stoichiometric activators include tri-substituted boron, thallium, aluminum, gallium and indium or mixtures thereof. The three substituent groups are each independently selected from alkyls, alkenyls, halogen, substituted alkyls, aryls, arylhalides, alkoxy and halides. Preferably, the three groups are independently selected from halogen, mono or multicyclic (including halosubstituted) aryls, alkyls, and alkenyl compounds and mixtures thereof, preferred are alkenyl groups having 1 to 20 carbon atoms, alkyl groups having 1 to 20 carbon atoms, alkoxy groups having 1 to 20 carbon atoms and aryl groups having 3 to 20 carbon atoms (including substituted aryls). More preferably, the three groups are alkyls having 1 to 4 carbon groups, phenyl, naphthyl or mixtures thereof. Even more preferably, the three groups are halogenated, preferably fluorinated, aryl groups. Most preferably, the neutral stoichiometric activator is tris(perfluorophenyl) boron or tris(perfluoronaphthyl) boron.

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[0039] Ionic stoichiometric activator compounds may contain an active proton, or some other cation associated with, but not coordinated to, or only loosely coordinated to, the remaining ion of the ionizing compound. Such compounds and the like are described in European publications EP-A-0 570 982, EP-A-0 520 732, EP-A-0 495 375, EP-B1-0 500 944, EP-A-0 277 003 and EP-A-0 277 004, and U.S. Patent Nos. 5,153,157, 5,198,401, 5,066,741, 5,206,197, 5,241,025, 5,384,299 and 5,502,124 and U.S. Patent Application Serial No. 08/285,380, filed August 3, 1994, all of which are herein fully incorporated by reference.

[0040] In a preferred embodiment, the stoichiometric activators include a cation and an anion component, and may be represented by the following formula:



wherein L is a neutral Lewis base;

H is hydrogen;

$(L-H)^+$ is a Bronsted acid;

A^{d-} is a non-coordinating anion having the charge d^- ;

d is an integer from 1 to 3.

[0041] The cation component, $(L-H)_d^+$ may include Bronsted acids such as protons or protonated Lewis bases or reducible Lewis acids capable of protonating or abstracting a moiety, such as an alkyl or aryl, from the bulky ligand metallocene or Group 15 containing transition metal catalyst precursor, resulting in a cationic transition metal species.

[0042] The activating cation $(L-H)_d^+$ may be a Bronsted acid, capable of donating a proton to the transition metal catalytic precursor resulting in a transition metal cation, including ammoniums, oxoniums, phosphoniums, silyliums and mixtures thereof, preferably ammoniums of methylamine, aniline, dimethylamine, diethylamine, N-methylaniline, diphenylamine, trimethylamine, triethylamine, N,N-dimethylaniline, methyldiphenylamine, pyridine, p-bromo N,N-dimethylaniline, p-

nitro-N,N-dimethylaniline, phosphoniums from triethylphosphine, triphenylphosphine, and diphenylphosphine, oxoniums from ethers such as dimethyl ether diethyl ether, tetrahydrofuran and dioxane, sulfoniums from thioethers, such as diethyl thioethers and tetrahydrothiophene and mixtures thereof. The activating cation $(L-H)_d^+$ may also be an abstracting moiety such as silver, carboniums, tropylium, carbeniums, ferroceniums and mixtures, preferably carboniums and ferroceniums. Most preferably $(L-H)_d^+$ is triphenyl carbonium.

[0043] The anion component A^{d-} include those having the formula $[M^{k+}Q_n]^{d-}$ wherein k is an integer from 1 to 3; n is an integer from 2-6; $n - k = d$; M is an element selected from Group 13 of the Periodic Table of the Elements, preferably boron or aluminum, and Q is independently a hydride, bridged or unbridged dialkylamido, halide, alkoxide, aryloxy, hydrocarbyl, substituted hydrocarbyl, halocarbyl, substituted halocarbyl, and halosubstituted-hydrocarbyl radicals, said Q having up to 20 carbon atoms with the proviso that in not more than 1 occurrence is Q a halide. Preferably, each Q is a fluorinated hydrocarbyl group having 1 to 20 carbon atoms, more preferably each Q is a fluorinated aryl group, and most preferably each Q is a pentafluoryl aryl group. Examples of suitable A^{d-} also include diboron compounds as disclosed in U.S. Pat. No. 5,447,895, which is fully incorporated herein by reference.

[0044] Most preferably, the ionic stoichiometric activator $(L-H)_d^+ (A^{d-})$ is N,N-dimethylanilinium tetra(perfluorophenyl)borate or triphenylcarbenium tetra(perfluorophenyl)borate.

[0045] In one embodiment, an activation method using ionizing ionic compounds not containing an active proton but capable of producing a bulky ligand metallocene catalyst cation and their non-coordinating anion are also contemplated, and are described in EP-A- 0 426 637, EP-A- 0 573 403 and U.S. Patent No. 5,387,568, which are all herein incorporated by reference.

Supports, Carriers and General Supporting Techniques

[0046] Although not preferred, the catalyst system of the invention can include a support material or carrier, or a supported activator. For example, the catalyst compound of the invention can be deposited on, contacted with, vaporized with, bonded to, or incorporated within, adsorbed or absorbed in, or on, a support or carrier.

A. Support Material

[0047] The support material, if used, can be any of the conventional support materials. Preferably the supported material is a porous support material, for example, talc, inorganic oxides and inorganic chlorides. Other support materials include resinous support materials such as polystyrene, functionalized or crosslinked organic supports, such as polystyrene divinyl benzene polyolefins or polymeric compounds, zeolites, clays, or any other organic or inorganic support material and the like, or mixtures thereof.

[0048] The preferred support materials are inorganic oxides that include those Group 2, 3, 4, 5, 13 or 14 metal oxides. The preferred supports include silica, fumed silica, alumina (WO 99/60033), silica-alumina and mixtures thereof. Other useful supports include magnesia, titania, zirconia, magnesium chloride (U.S. Patent No. 5,965,477), montmorillonite (European Patent EP-B1 0 511 665), phyllosilicate, zeolites, talc, clays (U.S. Patent No. 6,034,187) and the like. Also, combinations of these support materials may be used, for example, silica-chromium, silica-alumina, silica-titania and the like. Additional support materials may include those porous acrylic polymers described in EP 0 767 184 B1, which is incorporated herein by reference. Other support materials include nanocomposites as described in PCT WO 99/47598, aerogels as described in WO 99/48605, spherulites as described in U.S. Patent No. 5,972,510 and polymeric beads as described in WO 99/50311, which are all herein incorporated by reference. A preferred support is fumed silica available under the trade name Cabosil™ TS-610, available from Cabot Corporation. Fumed

silica is typically a silica with particles 7 to 30 nanometers in size that has been treated with dimethylsilyldichloride such that a majority of the surface hydroxyl groups are capped.

[0049] It is preferred that the support material, most preferably an inorganic oxide, has a surface area in the range of from about 10 to about 700 m²/g, pore volume in the range of from about 0.1 to about 4.0 cc/g and average particle size in the range of from about 5 to about 500 μm. More preferably, the surface area of the support material is in the range of from about 50 to about 500 m²/g, pore volume of from about 0.5 to about 3.5 cc/g and average particle size of from about 10 to about 200 μm. Most preferably the surface area of the support material is in the range is from about 100 to about 400 m²/g, pore volume from about 0.8 to about 3.0 cc/g and average particle size is from about 5 to about 100 μm. The average pore size of the carrier of the invention typically has pore size in the range of from 10 to 1000Å, preferably 50 to about 500Å, and most preferably 75 to about 350Å.

[0050] The support materials may be treated chemically, for example with a fluoride compound as described in WO 00/12565, which is herein incorporated by reference. Other supported activators are described in for example WO 00/13792 that refers to supported boron containing solid acid complex.

[0051] In a preferred method of forming a supported catalyst composition component, the amount of liquid in which the activator is present is in an amount that is less than four times the pore volume of the support material, more preferably less than three times, even more preferably less than two times; preferred ranges being from 1.1 times to 3.5 times range and most preferably in the 1.2 to 3 times range. In an alternative embodiment, the amount of liquid in which the activator is present is from one to less than one times the pore volume of the support material utilized in forming the supported activator.

[0052] Procedures for measuring the total pore volume of a porous support are well known in the art. Details of one of these procedures is discussed in Volume 1, *Experimental Methods in Catalytic Research* (Academic Press, 1968) (specifically see pages 67-96). This preferred procedure involves the use of a classical BET apparatus for nitrogen absorption. Another method well known in the art is described in Innes, *Total Porosity and Particle Density of Fluid Catalysts By Liquid Titration*, Vol. 28, No. 3, Analytical Chemistry 332-334 (March, 1956).

B. Supported Activators

[0053] In one embodiment, the catalyst composition includes a supported activator. Many supported activators are described in various patents and publications which include: U.S. Patent No. 5,728,855 directed to the forming a supported oligomeric alkylaluminumoxane formed by treating a trialkylaluminum with carbon dioxide prior to hydrolysis; U.S. Patent No. 5,831,109 and 5,777,143 discusses a supported methylalumoxane made using a non-hydrolytic process; U.S. Patent No. 5,731,451 relates to a process for making a supported alumoxane by oxygenation with a trialkylsiloxy moiety; U.S. Patent No. 5,856,255 discusses forming a supported auxiliary catalyst (alumoxane or organoboron compound) at elevated temperatures and pressures; U.S. Patent No. 5,739,368 discusses a process of heat treating alumoxane and placing it on a support; EP-A-0 545 152 relates to adding a metallocene to a supported alumoxane and adding more methylalumoxane; U.S. Patent Nos. 5,756,416 and 6,028,151 discuss a catalyst composition of a alumoxane impregnated support and a metallocene and a bulky aluminum alkyl and methylalumoxane; EP-B1-0 662 979 discusses the use of a metallocene with a catalyst support of silica reacted with alumoxane; PCT WO 96/16092 relates to a heated support treated with alumoxane and washing to remove unfixed alumoxane; U.S. Patent Nos. 4,912,075, 4,937,301, 5,008,228, 5,086,025, 5,147,949, 4,871,705, 5,229,478, 4,935,397, 4,937,217 and 5,057,475, and PCT WO 94/26793 all directed to adding a metallocene to a supported activator; U.S. Patent No. 5,902,766 relates to a supported activator having a specified distribution of alumoxane on the silica

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particles; U.S. Patent No. 5,468,702 relates to aging a supported activator and adding a metallocene; U.S. Patent No. 5,968,864 discusses treating a solid with alumoxane and introducing a metallocene; EP 0 747 430 A1 relates to a process using a metallocene on a supported methylalumoxane and trimethylaluminum; EP 0 969 019 A1 discusses the use of a metallocene and a supported activator; EP-B2-0 170 059 relates to a polymerization process using a metallocene and a organo-aluminum compound, which is formed by reacting aluminum trialkyl with a water containing support; U.S. Patent No. 5,212,232 discusses the use of a supported alumoxane and a metallocene for producing styrene based polymers; U.S. Patent No. 5,026,797 discusses a polymerization process using a solid component of a zirconium compound and a water-insoluble porous inorganic oxide preliminarily treated with alumoxane; U.S. Patent No. 5,910,463 relates to a process for preparing a catalyst support by combining a dehydrated support material, an alumoxane and a polyfunctional organic crosslinker; U.S. Patent Nos. 5,332,706, 5,473,028, 5,602,067 and 5,420,220 discusses a process for making a supported activator where the volume of alumoxane solution is less than the pore volume of the support material; WO 98/02246 discusses silica treated with a solution containing a source of aluminum and a metallocene; WO 99/03580 relates to the use of a supported alumoxane and a metallocene; EP-A1-0 953 581 discloses a heterogeneous catalytic system of a supported alumoxane and a metallocene; U.S. Patent No. 5,015,749 discusses a process for preparing a polyhydrocarbyl-alumoxane using a porous organic or inorganic imbibitor material; U.S. Patent Nos. 5,446,001 and 5,534,474 relates to a process for preparing one or more alkylaluminoxanes immobilized on a solid, particulate inert support; and EP-A1-0 819 706 relates to a process for preparing a solid silica treated with alumoxane. Also, the following articles, also fully incorporated herein by reference for purposes of disclosing useful supported activators and methods for their preparation, include: W. Kaminsky, et al., "Polymerization of Styrene with Supported Half-Sandwich Complexes", Journal of Polymer Science Vol. 37, 2959-2968 (1999) describes a process of adsorbing a methylalumoxane to a support followed by the adsorption of a metallocene; Junting Xu, et al. "Characterization of isotactic polypropylene prepared

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with dimethylsilyl bis(1-indenyl)zirconium dichloride supported on methylaluminoxane pretreated silica", European Polymer Journal 35 (1999) 1289-1294, discusses the use of silica treated with methylalumoxane and a metallocene; Stephen O'Brien, et al., "EXAFS analysis of a chiral alkene polymerization catalyst incorporated in the mesoporous silicate MCM-41" Chem. Commun. 1905-1906 (1997) discloses an immobilized alumoxane on a modified mesoporous silica; and F.Bonini, et al., "Propylene Polymerization through Supported Metallocene/MAO Catalysts: Kinetic Analysis and Modeling" Journal of Polymer Science, Vol. 33 2393-2402 (1995) discusses using a methylalumoxane supported silica with a metallocene. Any of the methods discussed in these references are useful for producing the supported activator component utilized in the catalyst composition of the invention and all are incorporated herein by reference.

[0054] In another embodiment, the supported activator, such as supported alumoxane, is aged for a period of time prior to use herein. For reference please refer to U.S. Patent Nos. 5,468,702 and 5,602,217, incorporated herein by reference.

[0055] In an embodiment, the supported activator is in a dried state or a solid. In another embodiment, the supported activator is in a substantially dry state or a slurry, preferably in a mineral oil slurry.

[0056] In another embodiment, two or more separately supported activators are used, or alternatively, two or more different activators on a single support are used.

[0057] In another embodiment, the support material, preferably partially or totally dehydrated support material, preferably 200°C to 600°C dehydrated silica, is then contacted with an organoaluminum or alumoxane compound. Preferably in an embodiment where an organoaluminum compound is used, the activator is formed in

situ on and in the support material as a result of the reaction of, for example, trimethylaluminum and water.

[0058] In another embodiment, Lewis base-containing supports are reacted with a Lewis acidic activator to form a support bonded Lewis acid compound. The Lewis base hydroxyl groups of silica are exemplary of metal/metalloid oxides where this method of bonding to a support occurs. This embodiment is described in U.S. Patent Application No. 09/191,922, filed November 13, 1998, which is herein incorporated by reference.

[0059] Other embodiments of supporting an activator are described in U.S. Patent No. 5,427,991, where supported non-coordinating anions derived from tris(perfluorophenyl) boron are described; U.S. Patent No. 5,643,847 discusses the reaction of Group 13 Lewis acid compounds with metal oxides such as silica and illustrates the reaction of tris(perfluorophenyl) boron with silanol groups (the hydroxyl groups of silicon) resulting in bound anions capable of protonating transition metal organometallic catalyst compounds to form catalytically active cations counterbalanced by the bound anions; immobilized Group IIIA Lewis acid catalysts suitable for carbocationic polymerizations are described in U.S. Patent No. 5,288,677; and James C.W. Chien, *Jour. Poly. Sci.: Pt A: Poly. Chem.*, Vol. 29, 1603 - 1607 (1991), describes the olefin polymerization utility of methylalumoxane (MAO) reacted with silica (SiO₂) and metallocenes and describes a covalent bonding of the aluminum atom to the silica through an oxygen atom in the surface hydroxyl groups of the silica.

[0060] In a preferred embodiment, a supported activator is formed by preparing in an agitated, and temperature and pressure controlled vessel a solution of the activator and a suitable solvent, then adding the support material at temperatures from 0°C to 100°C, contacting the support with the activator solution for up to 24 hours, then using a combination of heat and pressure to remove the solvent to produce a free flowing powder. Temperatures can range from 40 to 120°C and pressures from 5 psia

to 20 psia (34.5 to 138kPa). An inert gas sweep can also be used in assist in removing solvent. Alternate orders of addition, such as slurrying the support material in an appropriate solvent then adding the activator, can be used.

Polymerization Process

[0061] The catalyst systems prepared and the method of catalyst system addition described above are suitable for use in any prepolymerization and/or polymerization process over a wide range of temperatures and pressures. The temperatures may be in the range of from -60 °C to about 280°C, preferably from 50°C to about 200°C, and the pressures employed may be in the range from 1 atmosphere to about 500 atmospheres or higher.

[0062] Polymerization processes include solution, gas phase, slurry phase and a high pressure process or a combination thereof. Particularly preferred is a gas phase or slurry phase polymerization of one or more olefins at least one of which is ethylene or propylene.

[0063] In one embodiment, the process of this invention is directed toward a solution, high pressure, slurry or gas phase polymerization process of one or more olefin monomers having from 2 to 30 carbon atoms, preferably 2 to 12 carbon atoms, and more preferably 2 to 8 carbon atoms. The invention is particularly well suited to the polymerization of two or more olefin monomers of ethylene, propylene, butene-1, pentene-1, 4-methyl-pentene-1, hexene-1, octene-1 and decene-1.

[0064] Other monomers useful in the process of the invention include ethylenically unsaturated monomers, diolefins having 4 to 18 carbon atoms, conjugated or nonconjugated dienes, polyenes, vinyl monomers and cyclic olefins. Non-limiting monomers useful in the invention may include norbornene, norbornadiene,

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isobutylene, isoprene, vinylbenzocyclobutane, styrenes, alkyl substituted styrene, ethylidene norbornene, dicyclopentadiene and cyclopentene.

[0065] In the most preferred embodiment of the process of the invention, a copolymer of ethylene is produced, where with ethylene, a comonomer having at least one alpha-olefin having from 3 to 15 carbon atoms, preferably from 4 to 12 carbon atoms, and most preferably from 4 to 8 carbon atoms, is polymerized in a gas phase process.

[0066] In another embodiment of the process of the invention, ethylene or propylene is polymerized with at least two different comonomers, optionally one of which may be a diene, to form a terpolymer.

[0067] In an embodiment, the mole ratio of comonomer to ethylene, C_x/C_2 , where C_x is the amount of comonomer and C_2 is the amount of ethylene is between about 0.001 to 0.200 and more preferably between about 0.002 to 0.008.

[0068] In one embodiment, the invention is directed to a polymerization process, particularly a gas phase or slurry phase process, for polymerizing propylene alone or with one or more other monomers including ethylene, and/or other olefins having from 4 to 12 carbon atoms. Polypropylene polymers may be produced using the particularly bridged bulky ligand metallocene catalysts as described in U.S. Patent Nos. 5,296,434 and 5,278,264, both of which are herein incorporated by reference.

[0069] Typically in a gas phase polymerization process a continuous cycle is employed where in one part of the cycle of a reactor system, a cycling gas stream, otherwise known as a recycle stream or fluidizing medium, is heated in the reactor by the heat of polymerization. This heat is removed from the recycle composition in another part of the cycle by a cooling system external to the reactor. Generally, in a gas fluidized bed process for producing polymers, a gaseous stream containing one or

more monomers is continuously cycled through a fluidized bed in the presence of a catalyst under reactive conditions. The gaseous stream is withdrawn from the fluidized bed and recycled back into the reactor. Simultaneously, polymer product is withdrawn from the reactor and fresh monomer is added to replace the polymerized monomer. (See for example U.S. Patent Nos. 4,543,399, 4,588,790, 5,028,670, 5,317,036, 5,352,749, 5,405,922, 5,436,304, 5,453,471, 5,462,999, 5,616,661 and 5,668,228, all of which are fully incorporated herein by reference.)

[0070] The reactor pressure in a gas phase process may vary from about 100 psig (690 kPa) to about 600 psig (4138 kPa), preferably in the range of from about 200 psig (1379 kPa) to about 400 psig (2759 kPa), more preferably in the range of from about 250 psig (1724 kPa) to about 350 psig (2414 kPa).

[0071] The reactor temperature in a gas phase process may vary from about 30°C to about 120°C, preferably from about 60°C to about 115°C, more preferably in the range of from about 70°C to 110°C, and most preferably in the range of from about 70°C to about 95°C.

[0072] Other gas phase processes contemplated by the process of the invention include series or multistage polymerization processes. Also gas phase processes contemplated by the invention include those described in U.S. Patent Nos. 5,627,242, 5,665,818 and 5,677,375, and European publications EP-A- 0 794 200 EP-B1-0 649 992, EP-A- 0 802 202 and EP-B- 634 421 all of which are herein fully incorporated by reference.

[0073] In a preferred embodiment, the reactor utilized in the present invention is capable of and the process of the invention is producing greater than 500 lbs of polymer per hour (227 Kg/hr) to about 200,000 lbs/hr (90,900 Kg/hr) or higher of polymer, preferably greater than 1000 lbs/hr (455 Kg/hr), more preferably greater

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than 10,000 lbs/hr (4540 Kg/hr), even more preferably greater than 25,000 lbs/hr (11,300 Kg/hr), still more preferably greater than 35,000 lbs/hr (15,900 Kg/hr), still even more preferably greater than 50,000 lbs/hr (22,700 Kg/hr) and most preferably greater than 65,000 lbs/hr (29,000 Kg/hr) to greater than 100,000 lbs/hr (45,500 Kg/hr).

[0074] A slurry polymerization process generally uses pressures in the range of from about 1 to about 50 atmospheres and even greater and temperatures in the range of 0°C to about 120°C. In a slurry polymerization, a suspension of solid, particulate polymer is formed in a liquid polymerization diluent medium to which ethylene and comonomers and often hydrogen along with catalyst are added. The suspension including diluent is intermittently or continuously removed from the reactor where the volatile components are separated from the polymer and recycled, optionally after a distillation, to the reactor. The liquid diluent employed in the polymerization medium is typically an alkane having from 3 to 7 carbon atoms, preferably a branched alkane. The medium employed should be liquid under the conditions of polymerization and relatively inert. When a propane medium is used the process must be operated above the reaction diluent critical temperature and pressure. Preferably, a hexane or an isobutane medium is employed.

[0075] A preferred polymerization technique of the invention is referred to as a particle form polymerization, or a slurry process where the temperature is kept below the temperature at which the polymer goes into solution. Such technique is well known in the art, and described in for instance U.S. Patent No. 3,248,179 which is fully incorporated herein by reference. Other slurry processes include those employing a loop reactor and those utilizing a plurality of stirred reactors in series, parallel, or combinations thereof. Non-limiting examples of slurry processes include continuous loop or stirred tank processes. Also, other examples of slurry processes

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are described in U.S. Patent No. 4,613,484 and 5,986,021, which are herein fully incorporated by reference.

[0076] In an embodiment the reactor used in the slurry process of the invention is capable of and the process of the invention is producing greater than 2000 lbs of polymer per hour (907 Kg/hr), more preferably greater than 5000 lbs/hr (2268 Kg/hr), and most preferably greater than 10,000 lbs/hr (4540 Kg/hr). In another embodiment the slurry reactor used in the process of the invention is producing greater than 15,000 lbs of polymer per hour (6804 Kg/hr), preferably greater than 25,000 lbs/hr (11,340 Kg/hr) to about 100,000 lbs/hr (45,500 Kg/hr). Examples of solution processes are described in U.S. Patent Nos. 4,271,060, 5,001,205, 5,236,998, 5,589,555 and 5,977,251 and PCT WO 99/32525 and PCT WO 99/40130, which are fully incorporated herein by reference

[0077] A preferred process of the invention is where the process, preferably a slurry or gas phase process is operated in the presence of a bulky ligand metallocene catalyst system of the invention and in the absence of or essentially free of any scavengers, such as triethylaluminum, trimethylaluminum, tri-isobutylaluminum and tri-n-hexylaluminum and diethyl aluminum chloride, dibutyl zinc and the like. This preferred process is described in PCT publication WO 96/08520 and U.S. Patent No. 5,712,352 and 5,763,543, which are herein fully incorporated by reference.

[0078] In one embodiment of the invention, olefin(s), preferably C₂ to C₃₀ olefin(s) or alpha-olefin(s), preferably ethylene or propylene or combinations thereof are prepolymerized in the presence of the metallocene catalyst systems of the invention described above prior to the main polymerization. The prepolymerization can be carried out batchwise or continuously in gas, solution or slurry phase including at elevated pressures. The prepolymerization can take place with any olefin monomer or combination and/or in the presence of any molecular weight controlling agent such

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as hydrogen. For examples of prepolymerization procedures, see U.S. Patent Nos. 4,748,221, 4,789,359, 4,923,833, 4,921,825, 5,283,278 and 5,705,578 and European publication EP-B-0279 863 and PCT Publication WO 97/44371 all of which are herein fully incorporated by reference.

[0079] In one embodiment, toluene is not used in the preparation or polymerization process of this invention.

Polymer Products

[0080] The polymers produced by the process of the invention can be used in a wide variety of products and end-use applications. The polymers produced by the process of the invention include linear low-density polyethylene, elastomers, plastomers, high density polyethylenes, medium density polyethylenes, low density polyethylenes, polypropylene and polypropylene copolymers. Also produced are isotactic polymers, such as poly-1-hexene.

[0081] The polymers, typically ethylene based polymers, have a density in the range of from 0.86 g/cc to 0.97 g/cc, preferably in the range of from 0.88 g/cc to 0.965 g/cc, more preferably in the range of from 0.900 g/cc to 0.96 g/cc, even more preferably in the range of from 0.905 g/cc to 0.95 g/cc, yet even more preferably in the range from 0.910 g/cc to 0.940 g/cc, and most preferably greater than 0.915 g/cc, preferably greater than 0.920 g/cc, and most preferably greater than 0.925 g/cc. Density is measured in accordance with ASTM-D-1238.

[0082] The polymers produced by the process of the invention typically have a molecular weight distribution, a weight average molecular weight to number average molecular weight (M_w/M_n) of greater than 1.5 to about 30, particularly greater than 2 to about 10, more preferably greater than about 2.2 to less than about 8, and most preferably from 2.5 to 8.

[0083] Also, the polymers of the invention typically have a narrow composition distribution as measured by Composition Distribution Breadth Index (CDBI). Further details of determining the CDBI of a copolymer are known to those skilled in the art. See, for example, PCT Patent Application WO 93/03093, published February 18, 1993, which is fully incorporated herein by reference.

[0084] The polymers of the invention in one embodiment have CDBI's generally in the range of greater than 50% to 100%, preferably 99%, preferably in the range of 55% to 85%, and more preferably 60% to 80%, even more preferably greater than 60%, still even more preferably greater than 65%.

[0085] In another embodiment, polymers produced using a catalyst system of the invention have a CDBI less than 50%, more preferably less than 40%, and most preferably less than 30%.

[0086] The polymers of the present invention in one embodiment have a melt index (MI) or (I_2) as measured by ASTM-D-1238-E in the range from no measurable flow to 1000 dg/min, more preferably from about 0.01 dg/min to about 100 dg/min, even more preferably from about 0.1 dg/min to about 50 dg/min, and most preferably from about 0.1 dg/min to about 10 dg/min.

[0087] The polymers of the invention in an embodiment have a melt index ratio (I_2/I_1) (I_2 is measured by ASTM-D-1238-F) of from 10 to less than 25, more preferably from about 15 to less than 25.

[0088] The polymers of the invention in a preferred embodiment have a melt index ratio (I_2/I_1) of from preferably greater than 25, more preferably greater than 30, even more preferably greater than 40, still even more preferably greater than 50 and most preferably greater than 65. In an embodiment, the polymer of the invention may have a narrow molecular weight distribution and a broad composition distribution or vice-

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versa, and may be those polymers described in U.S. Patent No. 5,798,427 incorporated herein by reference.

[0089] In yet another embodiment, propylene based polymers are produced in the process of the invention. These polymers include atactic polypropylene, isotactic polypropylene, hemi-isotactic and syndiotactic polypropylene. Other propylene polymers include propylene block or impact copolymers. Propylene polymers of these types are well known in the art see for example U.S. Patent Nos. 4,794,096, 3,248,455, 4,376,851, 5,036,034 and 5,459,117, all of which are herein incorporated by reference.

[0090] The polymers of the invention may be blended and/or co-extruded with any other polymer. Non-limiting examples of other polymers include linear low density polyethylenes, elastomers, plastomers, high pressure low density polyethylene, high density polyethylenes, polypropylenes and the like.

[0091] Polymers produced by the process of the invention and blends thereof are useful in such forming operations as film, sheet, and fiber extrusion and co-extrusion as well as blow molding, injection molding and rotary molding. Films include blown or cast films formed by co-extrusion or by lamination useful as shrink film, cling film, stretch film, sealing films, oriented films, snack packaging, heavy duty bags, grocery sacks, baked and frozen food packaging, medical packaging, industrial liners, membranes, etc. in food-contact and non-food contact applications. Fibers include melt spinning, solution spinning and melt blown fiber operations for use in woven or non-woven form to make filters, diaper fabrics, medical garments, geotextiles, etc. Extruded articles include medical tubing, wire and cable coatings, pipe, geomembranes, and pond liners. Molded articles include single and multi-layered constructions in the form of bottles, tanks, large hollow articles, rigid food containers and toys, etc.

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[0092] The present invention will be illustrated in more detail with reference to the following examples, which should not be construed to be limiting in scope of the present invention.

Glossary

[0093] Activity is measured in g of polyethylene/mmol of metal per hr at 100 psig ethylene.

[0094] I2 is the flow index (dg/min) as measured by ASTM D-1238-Condition E at 190°C.

[0095] I21 is the flow index (dg/min) as measured by ASTM D-1238-Condition F.

[0096] MFR is the Melt Flow Ratio, I21/I2.

[0097] MMAO is a solution of modified methylalumoxane in heptane, approximately 1.9 molar in aluminum, commercially available from Akzo Chemicals, Inc. (type 3).

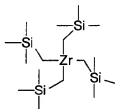
[0098] BBF is Butyl Branching Frequency, number of butyl branches per 1000 main chain carbon atoms, as determined by infrared measurement techniques.

[0099] M_w is Weight Average Molecular Weight, as determined by gel permeation chromatography using crosslinked polystyrene columns; pore size sequence: 1 column less than 1000 Å, 3 columns of mixed 5×10^7 Å; 1,2,4-trichlorobenzene solvent at 140°C, with refractive index detection. M_n is number average molecular weight.

[00100] PDI is the Polydispersity Index, equivalent to Molecular Weight Distribution (M_w/M_n).

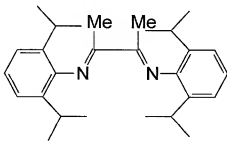
EXAMPLES

[00101] Preparation of Tetrakis(trimethylsilylmethyl)zirconium



Tetrakis(trimethylsilylmethyl)zirconium was prepared following Collier, M. R., Lappert, M. F., Pearce, R.; "Silylmethyl and Related Complexes. Part I. Kinetically stable Alkyls of Ti(IV), Zr(IV) and Hf(IV)." J.C.S. Dalton, 1973, pp745.

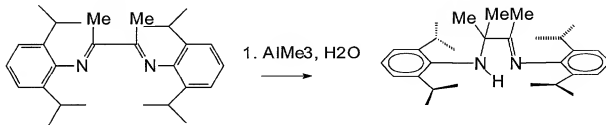
[00102] Preparation of diacetyl-bis(2,6-diisopropylphenylimine) diazabutadiene



[00103] **General procedure:** Into a 300mL flask equipped with a stir bar was charged 100 mmol 2,6-diisopropylaniline and 100 mL methanol. The solution was chilled to 0°C and 0.19 mL formic acid was added to the stirring solution. When the solution reached room temperature (RT) 50 mmol 2,3-butanedione was added. The solution was allowed to stir overnight, then filtered to collect the yellow solids. The crude product was dissolved in hexane and dried over Na_2SO_4 . The mixture was

filtered and the filtrate vacuum stripped. The solids were then recrystallized from methanol/ethanol.

[00104] Monoalkylation of the diazabutadiene



[00105] General procedure: Diacetyl-bis(2,6-diisopropylphenylimine) (25 mmol, 10g) was dissolved in 25 mL toluene in a 100 mL Schlenk flask equipped with a stir bar and septa and chilled to 0°C. Trimethyl aluminum (25 mmol (12.5 mL) Aldrich, [2.0M soln in toluene]) was charged drop-wise via syringe. The reaction was allowed to slowly warm to about room temperature with stirring. When complete, the reaction was hydrolyzed with NaOH/H₂O and extracted with ether. The ether extracts were dried over MgSO₄ and filtered. The filtrate was vacuum stripped to a viscous orange residue.

[00106] Attempted reaction of monoalkylated diazabutadiene with (Me₃SiCH₂)₄Zr

[00107] General procedure: In a dry box, tetrakis(trimethylsilyl)-methyl) zirconium was charged to a 7 mL amber bottle equipped with a stir bar and screw cap. The monoalkylated diazabutadiene was charged to a vial. Benzene-d₆ (0.75 mL) was added to both vessels. The monoalkylated diazabutadiene solution was slowly transferred via pipette into the stirring zirconium solution. The reaction bottle was capped and allowed to stir for 18 hours at room temperature in the dry box. The solution was submitted for testing in the 1L slurry reactor. An aliquot to this reaction solution exhibited good ethylene polymerization activities at 85°C with MMAO

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cocatalyst. The carbon dimethyl bridged imino-amide $\text{Zr}[\text{CH}_2\text{SiMe}_3]_3$ compound is most likely present with other products as well. This result is attributed to a more optimized bridge. Hydrogen was an effective chain-transfer agent that does not appear to adversely affect catalyst activity.

[00108] Reaction Product Is An Active Ethylene Polymerization Catalyst With Low Co-monomer Incorporation

MMAO Cocatalyst,

C₆ mL H₂psi	Activity	I2	I21	MFR	BBF IR/nmr
43	0	81,400	.014	1.14	83.6 1.93/3.04
86	0	110,600	.037	1.63	44.7 4.59/4.70
43	10	93,600	.994	24.21	24.2 2.62/5.60

Reaction Conditions: 0.5 micromoles Zr, MMAO/Zr = 1,000, 85°C, 85 psi ethylene

Temp °C	Activity	BBF
65	154,000	~0
75	105,400	1.20
85	81,400	1.93

[00109] Reaction Conditions: 0.5 micromoles Zr, MMAO/Zr = 1,000, 85°C, 85 psi ethylene, 43 mL 1-hexene. Catalyst activities are calculated based on total zirconium in reaction mixture (i.e. Assumes a 100% yield of complex). Thus activity could be underestimated.

[00110] The catalyst was insitu-supported on a new batch of Witco SMAO cocatalyst (20 min contact time, 2 micromoles Zr, 500MAO/Zr, 200 micromole of triisobutylaluminum (TIBA) scavenger, 85°C, 85 psi ethylene)

SMAO Cocatalyst

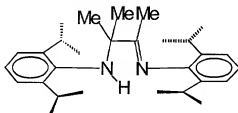
C₆ mL H₂psi	Activity	I2	I21	MFR	BBF
43	0	14,000	NF	NF	NF 7.48

MMAO Cocatalyst,

C₆ mL H₂psi	Activity	I2	I21	MFR	BBF IRmr
45	10	12,400	0.346	9.42	27.34 0

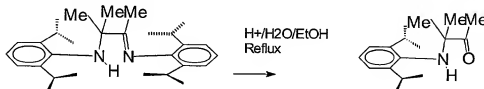
Reaction Conditions: 0.5 micromoles Zr, MMAO/Zr = 500, 85°C, 130 psi ethylene, 200 micromoles TIBA scavenger added to the reactor.

[00111] Attempted Reaction of monoalkylated diazabutadiene with Tetrabenzyl zirconium



[00112] General procedure: In a dry box, tetrabenzyl zirconium (0.200 mmol, 0.091g,) was charged to a 7 mL amber bottle equipped with a stir bar and screw cap. The monoalkylated compound was charged to a vial. Benzene- d_6 (1.5 mL) was added to both vessels. The monoalkylated diazabutadiene solution was slowly transferred via pipette into the stirring zirconium solution. The reaction bottle was capped and allowed to stir for 18 hours at room temperature in the dry box. $^1\text{H-NMR}$ analysis of reaction solution confirmed very little if any reaction occurred.

[00113] Hydrolysis of the monoalkylated diazabutadiene to Keto-Amine



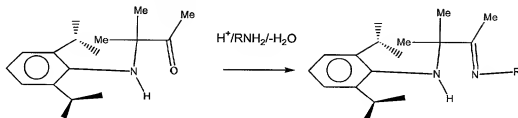
[00114] General procedure: Monoalkylated diazabutadiene (150.0 mmol, 60g) was charged to a 3 L 3-neck round-bottom flask equipped with a stir bar. A 750 mL addition funnel was attached to the reaction flask. Ethanol (750 mL) was added through the addition funnel to dissolve the monoalkylated compound. When completely dissolved, 250 mL water was added. Sulfuric acid (600 mmol, 600 mL of

1.0M soln in H₂O) was charged over a 1 hr. period to the addition funnel. A reflux condenser was then attached to the reaction flask and the reaction was heated to 85°C and allowed to reflux for 1 hour.

[00115] When the reaction was complete, the reaction solution was transferred into a 4L beaker equipped with a stir bar. Sodium hydroxide pellets were slowly added to the stirring solution until the pH reached 9.0. The solution was then extracted with toluene. The extracts were dried over MgSO₄, filtered and the filtrate vacuum stripped to a viscous yellow residue, than vacuum distilled with a short-path distillation apparatus.

[00116] The product was confirmed by ¹H- NMR in Benzene-d₆.

[00117] **n-Octylimine Amine Ligand Preparation**

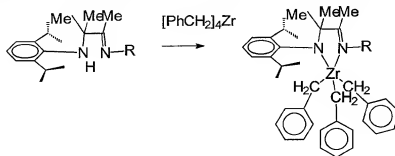


R = n-Octyl

[00118] **General preparation:** The hydrolysis product of monoalkylated diazabutadiene (1.9 mmol, 0.5g) was charged to a 25 mL Schlenk flask equipped with a stir bar and septa, Ether (5.0 mL) was added to dissolve the monoalkylated compound. Hydrogen chloride (0.1 mmol, 0.1 mL of 1.0M solution in ether) was added. n-Octylamine(100 mmol, 13 mL, Aldrich) was added via a syringe to the stirring reaction. A Dean-Stark apparatus was attached and the reaction heated to 60°C to drive off ether. The temperature was increased to 170°C to remove excess amine. The resulting brown residue was treated with NaOH/H₂O and extracted with

toluene. The extracts were dried over MgSO_4 , filtered and the filtrate vacuum stripped to liquid brown residue.

[00119] Reaction of n-Octylimine Amine Ligand with Tetrabenzyl zirconium



R = n-Octyl

[00120] General procedure: In a dry box, tetrabenzyl zirconium (0.200 mmol, 0.091g,) was charged to a 7 mL amber bottle equipped with a stir bar and screw cap. The n-octylimino Amine Ligand (0.200 mmol, 0.074g, was charged to a vial. Benzene- d_6 (1.5 mL) was added to both vessels. The n-octylimino amine ligand solution was slowly transferred via pipette into the stirring zirconium solution. The reaction bottle was capped and allowed to stir for 7 days at room temperature in the dry box.

[00121] Polymerization Of 1-Hexene With n-Octylimino Amide Zirconium(Tribenzyl) Based Catalyst

[00122] In a dry box, 10 mls of 1-hexene was charged to a 25 ml single neck flask containing a stir bar. Modified methyl aluminoxane (MMAO, 0.27 mls, 0.5 μmoles , 1.84M AKZO type 3A in heptane) was added to the 1-hexene. 0.5 μmoles of the n-octyl-imino-amide zirconium tribenzyl was added to the 1-hexene/ MMAO with stirring. After 54.5 hours of stirring at room temperature, the catalyst solution was quenched with 0.1 mls of methanol. The isolated polymer sample was analyzed by ^{13}C NMR. The ^{13}C NMR spectrum of the sample polymerized using n-Octyl-imino-amide zirconium tribenzyl catalyst evidenced that the sample was highly isotactic. The

percentage of pentad mmmm was then calculated to be 92% on the basis of line deconvolution. This is a measure of degree of isotacticity by NMR measurement.

Ethylene/Hexene Copolymerization:

[00123] The Reaction Product Is An Active Ethylene Polymerization Catalyst With Significant Comonomer Incorporation

MMAO Cocatalyst, (n-Octyl)Imino-AmideZr

C ₆ mL H ₂	psi	Activity	I ₂	I ₂₁	MFR	BBF
43	0	151,059	0.031	0.562	18.33	24.36
43	0	164,706	0.046	0.773	16.75	21.66
43	5	23,059	29.18	188	6.44	14.59
43	2	87,059	3.66	70.92	19.36	16.21

Reaction Conditions: 0.5 micromoles Zr, MMAO/Zr = 1,000, 85°C, 85 psi ethylene

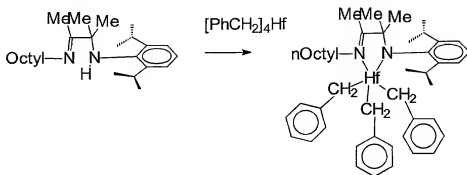
1-Hexene incorporation was considerably higher than the bulky 2,6-diisopropylphenyl imine derivative. Hence, the sterically less encumbering primary octyl group improves comonomer incorporation significantly.

[00124] The performance of the catalyst versus temperature was investigated and polymerization activity was still present at 105°C.

MMAO Cocatalyst, (n-Octyl)Imino-AmideZr

Temp, °C	Activity	I ₂	I ₂₁	MFR	BBF	IR
65	314,353	NF	NF	NF	20.32	
75	256,941	NF	NF	NF	16.31	
85	151,059	0.031	0.562	18.33	24.36	
85	164,706	0.046	0.773	16.75	21.66	
95	116,235	0.085	1.68	19.86	18.15	
100	67,765	0.18	3.06	17.03	17.87	
105	22,588	3.21	72.09	22.44	24.25	

Reaction Conditions: no H₂, 43 mL 1-Hexene, 0.5 micromoles Zr, MMAO/Zr = 1,000, 85 psi ethylene

[00125] Reaction of n-Octylimine Amine Ligand with Tetrabenzyl hafnium

[00126] General procedure: In a dry box, tetrabenzyl hafnium (0.200 mmol, 0.108g) was charged to a 7 mL amber bottle equipped with a stir bar and screw cap. n-Octylimine Amine Ligand (0.200 mmol, 0.074g) was charged to a vial. Benzene- d_6 (1.5 mL) was added to both vessels. The monoalkylated diazabutadiene solution was slowly transferred via pipette into the stirring hafnium solution. The reaction bottle was capped and allowed to stir for 5 days at room temperature in the dry box.

MMAO Cocatalyst, 0.5 micromoles

MMAO/Hf = 1,000

Run	Catalyst	Activity	I2	I21	MFR	BBF
14REMU23	13REMU15	107,765	0.051	1.07	21.334	21.3

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

[00127] Like the zirconium complex, the hafnium catalyst is a good incorporator of 1-hexene and yields melt indexable polyethylene. Activity is about two-thirds of zirconium. Lower Al/Hf was evaluated and it was found that activity and molecular weight decreased, but TIBA was also present at lower molecular weight.

MMAO Cocatalyst, 0.5 micromoles 85°C

MMAO/Hf	Activity	I2	I21	MFR	BBF
1,000	107,765	.051	1.07	21.334	21.3
300 (200 TIBA*)	54,588	.277	4.97	17.97	22.05

Conditions: 85 psi ethylene, 43 mL hexene, no hydrogen (TIBA* scavenger 200 micromoles).

[00128] Supported catalysts were evaluated with SMAO at 300/1 Al/Hf. In one experiment 5 psi hydrogen was used in an attempt to lower molecular weight, however we could not melt index the product and the activity dropped significantly.

SMAO Cocatalyst, 0.5 micromoles MMAO/Hf = 300

T	Activity	I2	I21	MFR	BBF
75	32,000	-	-	-	25.88
85	25,882	NF	NF	NF	51.09
95	1,176	-	-	-	-
85	8,000 (5psi H ₂)	NF	NF	-	38.23

Conditions: 85 psi ethylene, 43 mL hexene, no hydrogen (TIBA* scavenger 200 micromoles).

[00129] Reaction of n-Octylimine Amine Ligand with a pre-mixture of Tetrabenzyl Zirconium and Chromium (III) Chloride:

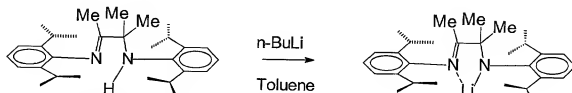
[00130] **General procedure:** In a dry box, chromium (III) chloride (0.400 mmol, 0.063g) was charged to a 7 mL amber bottle equipped with a stir bar and screw cap and treated with 1.5 mL of toluene. A solution of 300 mmoles of tetrabenzylzirconium was added to the chromium (III) chloride slurry and stirred for two weeks. A 1.0 mL aliquot of the resultant solution (0.10 mmoles Zr, 0.13 mmoles Cr) was treated with a 1.0 mL solution of the n-Octylimine Amine Ligand (0.230 mmol, 0.086g in toluene). The resultant catalyst was shown to exhibit polymerization activity with MMAO cocatalyst. Lower molecular weight polyethylene with lower hexene incorporation was noted with this novel bimetallic Zr/Cr catalyst approach than with the zirconium catalyst.

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MMAO Cocatalyst, (n-Octyl)Imino-AmideZr/Cr

C ₆ mL	H ₂ psi	Activity	I2	I21	MFR	BBF
43	0	24,471	5.67	143	24.3	8.16

Reaction Conditions: 0.5 micromoles Zr, MMAO/Zr = 1,000, 85°C, 85 psi ethylene

[00131] Reaction of monoalkylated diazabutadiene with butyl lithium

[00132] General procedure: In a the dry box monoalkylated diazabutadiene (25 mmol, 10.5g) was charged to a 100 mL Schlenk flask equipped with a stir bar and septum. Toluene (25 mL) was added to dissolve compound. Butyl lithium (10 mL, Aldrich, [2.5M solution in hexanes]) was slowly added. When the reaction was completed, the white solids were filtered from the orange solvent layer.

[00133] Reaction of the lithium salt of monoalkylated diazabutadiene with CrCl₃

[00134] General procedure: Chromium (III) chloride (0.400 mmol, 0.063g, Aldrich) was charged to a 7 mL amber bottle equipped with a stir bar and cap. Toluene (3 mL) was added. The lithium salt of monoalkylated diazabutadiene (0.400 mmol, 0.171g) was dissolved in 3.0 mL toluene and transferred into the stirring CrCl₃/toluene. The reaction was allowed to stir at room temperature in the dry box for 8 weeks. The solvent layer was decanted from the moderate amount of white solids and submitted for polymerization testing .

[00135] The polymerization activity for the chromium complex (derived from reaction with chromium trichloride, was conducted.

Chromium Catalyst, MMAO Cocatalyst, 0.5 micromoles MMAO/Cr = 1,000

<u>Activity</u>	<u>I2</u>	<u>I21</u>	<u>MFR</u>	<u>BBF</u>
6,118	NA	NA	NA	2.48

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

Other comonomer levels and Al/Cr ratios were evaluated.

Chromium Catalyst, MMAO Cocatalyst, 0.5 micromoles MMAO/Cr = 1,000

<u>Temp°C</u>	<u>mL Hexene</u>	<u>Activity</u>	<u>I2</u>	<u>I21</u>	<u>MFR</u>	<u>BBF</u>
85	43	6,118	NA	NA	NA	2.48
85	0	9412	NA	NA	NA	NA
75	43	6588	NA	NA	NA	NA
95	43	1835	NA	NA	NA	NA

Conditions: 85 psi ethylene, no hydrogen.

Chromium Catalyst, MMAO Cocatalyst, 2.0 micromoles MMAO/Cr = 1,000

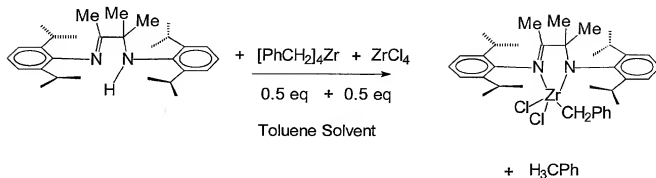
<u>mL Hexene</u>	<u>Activity</u>	<u>MMAO/Cr</u>	<u>I2</u>	<u>I21</u>	<u>MFR</u>	<u>BBF</u>
43	8000	1000	7.34	840	114	2.46
0	9176	1000	0.29	61.22	211	NA
43	4000	300	3.59	162	45.26	1.85

<u>Mn</u>	<u>Mw</u>	<u>PDI</u>
6508	151448	23.27
6374	206756	32.44
10626	174820	16.45

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

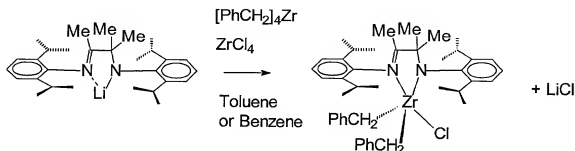
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[00136] Reaction of monoalkylated diazabutadiene with Tetrabenzyl zirconium/Zirconium (IV) chloride



[00137] General procedure: Tetrabenzyl zirconium (25 mmol, 11.4g) and 200 mL toluene were charged to a 500 mL bottle. The tetrabenzyl zirconium solution was transferred into the stirring zirconium (IV) chloride slurry and allowed to stir at room temperature for one hour. A solution of monoalkylated diazabutadiene (50 mmol, 21.0g) in 2000 mL of toluene was transferred into the stirring tetrabenzyl zirconium solution. A zirconium (IV) chloride (25 mmol, 5.3g) and 200 mL toluene slurry was transferred into the stirring solution. The mixture was allowed to stir at room temperature for 4 days. Toluene (600 mL) was added to the reaction solution.

[00138] Reaction of lithium salt of monoalkylated diazabutadiene with tetrabenzyl zirconium/zirconium (IV) chloride



[00139] General procedure: Zirconium (IV) chloride (0.050 mmol, 0.012g) was charged to a 7 mL amber bottle equipped with a stir bar and cap. Tetrabenzyl zirconium (0.150 mmol, 0.068g, [455.75]) was charged to a second bottle the lithium salt of monoalkylated diazabutadiene (0.200 mmol, 0.085g) was charged to a third bottle. Benzene- d_6 (1.0 ml) was added to each bottle. The lithium salt of monoalkylated diazabutadiene solution was transferred into the tetrabenzyl zirconium solution. The combined solution was transferred into the stirring slurry of $ZrCl_4$. The mixture was allowed to stir at room temperature overnight.

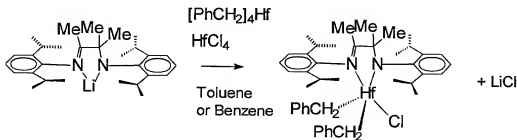
[00140] Polymerization activity has been determined for the 75:25 composition, which produced about a 50% yield of catalyst.

MMAO Cocatalyst, 0.5 micromoles MMAO/Zr = 1,000

Activity	I2	I2I	MFR	BBF
112,941	NF	<0.057 NF		3.39

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

[00141] Reaction of the lithium salt of monoalkylated diazabutadiene with Tetrabenzyl hafnium/Hafnium(IV) chloride



[00142] General procedure: Hafnium (IV) chloride (0.100 mmol, 0.032g) was charged to a 7 mL amber bottle equipped with a stir bar and cap. Tetrabenzyl hafnium (0.100 mmol, 0.054g) was charged to a second bottle. The lithium salt of monoalkylated diazabutadiene (0.200 mmol, 0.085g) was charged to a third bottle. Benzene- d_6 (1.0 ml) was added to each bottle. The lithium salt of monoalkylated diazabutadiene solution was transferred into the tetrabenzyl hafnium solution. The

combined solution was transferred into the stirring slurry of HfCl_4 . The mixture was allowed to stir at room temperature overnight.

50:50 TBHF:HfCl₄ MMAO Cocatalyst, 0.5 micromoles MMAO/Hf = 1,000

Activity	I2	I21	MFR	BBF
44,235	0.085	5.11	60.24	3.51

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

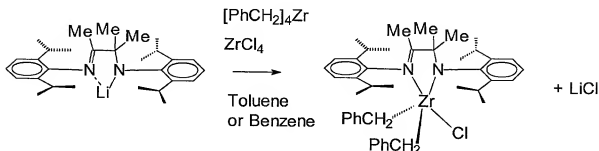
The MMAO/Hf ratio was lowered and it was found that activity decreased significantly at lower MMAO/Hf ratios.

50:50 TBHF:HfCl₄ MMAO Cocatalyst, 0.5 micromoles MMAO/Hf = 1,000

Al/Hf	Activity	I2	I21	MFR	BBF
1,000	44,235	0.085	5.11	60.24	3.51
300 (TIBA)	8,941	-	-	-	-

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

[00143] Reaction of lithium salt of monoalkylated diazabutadiene with tetrabenzyl zirconium/zirconium (IV) chloride



[00144] General procedure: Zirconium (IV) chloride (0.100 mmol, 0.023g) was charged to a 7 mL amber bottle equipped with a stir bar and cap. Tetrabenzyl zirconium (0.100 mmol, 0.046g, was charged to a second bottle. The lithium salt of monoalkylated diazabutadiene (0.200 mmol, 0.085g) was charged to a third bottle. Benzene- d_6 (1.0 ml) was added to each bottle. The 8-REMU-022 solution was transferred into the Tetrabenzyl zirconium solution. The combined solution was

transferred into the stirring slurry of ZrCl_4 . The mixture was allowed to stir at room temperature overnight.

[00145] The 50:50 mole ratio of tetrabenzylzirconium and zirconium tetrachloride was evaluated to produce the dibenzylchloro ZrL complex in 100% yield.

Polymerization activity was determined for the 50:50 composition (10REM4), 192,000.

75:25 TBZ/ ZrCl_4 MMAO Cocatalyst, 0.5 micromoles MMAO/ Zr = 1,000

Activity	I2	I21	MFR	BBF
112,941	NF	<0.057	NF	3.39

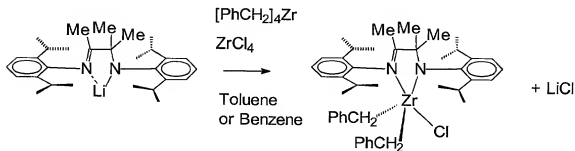
50:50 TBZ: ZrCl_4 MMAO Cocatalyst, 0.5 micromoles MMAO/ Zr = 1,000

Activity	I2	I21	MFR	BBF	IR
192,941	NF	NF	NF	3.95	

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

The 50:50 TBZ/ ZrCl_4 reaction composition was supported on SMAO.

[00146] SMAO With 50:50 TBZ: ZrCl_4



[00147] 50:50 mole ratios of tetrabenzylzirconium and zirconium tetrachloride were evaluated, with both MMAO (1000/1) and SMAO (300/1). The results are compared below.

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50:50 TBZ:ZrCl₄ MMAO Cocatalyst, 0.5 micromoles MMAO/Zr = 1,000

Activity	I2	I21	MFR	BBF
192,941	NF	NF	NF	3.95

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

50:50 TBZ:ZrCl₄ SMAO Cocatalyst, 0.5 micromoles SMAO/Zr = 300

Activity	I2	I21	MFR	BBF
43,765	NF	NF	NF	6.82

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

The supported catalyst with 10 psi Hydrogen Chain Transfer Agent was evaluated.

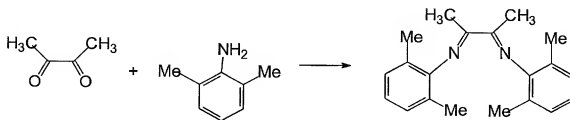
50:50 TBZ:ZrCl₄ SMAO Cocatalyst, 0.5 micromoles SMAO/Zr = 300

Activity	I2	I21	MFR	BBF
35,294	0.248	4.8	19.38	5.85

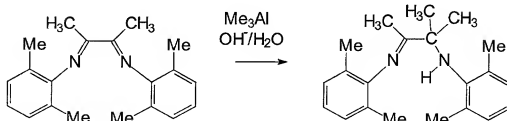
Conditions: 85°C, 85 psi ethylene, 43 mL hexene, 10 psi hydrogen.

A melt indexable polymer was produced.

[00148] Synthesis of Bis (2,6-Dimethylphenyl) diazabutadiene



[00149] General procedure: 2,3-Butanedione (100 mmol, 8.6g) was charged to a 100 mL Schlenk flask equipped with a stir bar and septum. Hydrochloric acid (5.0 mmol, 5.0 mL, [1.0M solution in ether]) was added with stirring under a nitrogen purge. 2,6-dimethylaniline (200 mmol, 24.2g) was added. A Dean-Stark apparatus was attached and the reaction heated to 105°C for 4 hrs and allowed to stir at room temperature overnight, then filtered and yellow solids were collected. The filtrate was allowed to stand overnight, then filtered a second crop of yellow solids was collected.

[00150] Alkylation of Bis (2,6-Dimethylphenyl) diazabutadiene

[00151] General procedure: Bis (2,6-Dimethylphenyl) diazabutadiene analogous to the monoalkylation of the diazabutadiene example, the above diazabutadiene compound (20 mmol, 5.8g,) was dissolved in toluene (10 mL) in a 50 mL Schlenk flask equipped with a stir bar and septum. The reaction vessel was placed under a nitrogen purge and chilled to 0° C. Trimethyl aluminum (29 mmol, 18.1 mL, [2.0M solution in toluene]) was charged dropwise. The reaction was allowed to slowly warm to room temperature. The entire reaction solution was hydrolyzed by transferring into a stirring solution of sodium hydroxide and water and extracted with toluene. The extracts were dried over MgSO₄ then filtered. The filtrate was vacuum stripped to 4.8g of red-orange liquid.

[00152] Reaction of Alkylated Bis (2,6-Dimethylphenyl) diazabutadiene with tetrakis(trimethylsilylmethyl)zirconium

[00153] General procedure: Tetrakis(trimethylsilylmethyl) zirconium (0.100 mmol, 0.044g) was charged to a 7 mL amber bottle equipped with a stir bar and cap. Alkylated bis (2,6-dimethylphenyl) diazabutadiene (0.100 mmol, 0.031g) was charged to a second bottle. Benzene-d₆ (0.75 mL) was added to each bottle. The solution of 10-REMU-071 was transferred into the stirring solution of tetrakis(trimethylsilylmethyl) zirconium. The reaction solution was allowed to stir at room temperature overnight. Analysis by ¹H NMR indicated very little reaction.

Zirconium (IV) chloride (0.005 mmol, 0.001g) was added to the reaction solution and allowed to stir overnight at room temperature.

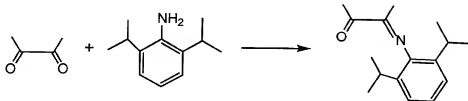
The mixture was evaluated with MMAO cocatalyst in a slurry polymerization.

MMAO Cocatalyst, 0.5 micromoles MMAO/Zr = 1,000

Run	Catalyst	Activity	I2	I21	MFR	BBF
12REMU6	10REMU103	10,706	NF	2.5	NF	
2.16						

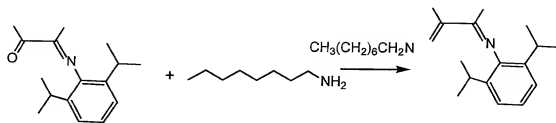
Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

[00154] Synthesis of 2,3-Butanedione (2,6-Diisopropylaniline)Mono-Imine



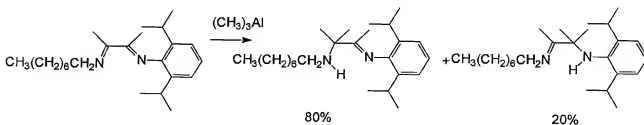
[00155] General procedure: 2,3-Butanedione (5000 mmol, 440 mL) was charged to a 3L flask equipped with a stir bar and septa. Hydrochloric acid (125 mL, [1.0M solution in ether]) was added with stirring. Methanol (1.0L) was added to dissolve. 2,6-Diisopropylaniline (2500 mmol, 470 mL) was added slowly into the stirring reaction. Reaction was allowed to stir at room temperature. When the reaction was complete a Vigreux fractional distillation head with a cold-water condenser was attached to the reaction flask and the reaction mixture distilled. The product was confirmed by ¹H NMR in Benzene-d₆.

[00156] Reaction of 2,3-Butanedione (2,6-Diisopropylaniline)Mono-Imine with n-octylamine



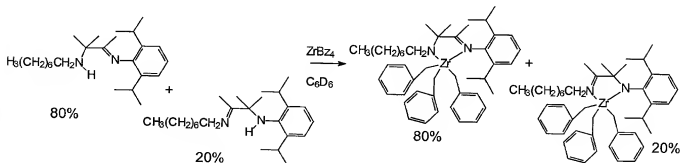
[00157] General procedure: 2,3-Butanedione (2,6-Diisopropylaniline)Mono-Imine (25 mmol, 6.1g), n-Octylamine (25 mmol, 3.2g) and . Hydrochloric acid (2.5 mmol, 2.5 ml, [1.0M solution in ether]) was charged to a 100 mL 2-neck flask equipped with a stir bar and septa. A Dean-Stark apparatus with a cold-water condenser was attached to the flask. The reaction was placed under a nitrogen purge and heated to 180°C for several hours. When the reaction was complete the Dean-Stark apparatus was replaced with a short path distillation apparatus. The reaction was distilled under high vacuum with heating. The distillation residue was dissolved in chloroform and loaded onto silica gel and eluted by column chromatography with 10:1 Hexane:Ethylacetate. The fractions were analyzed by gas chromatography to determine the possible product. Product was confirmed by ^1H NMR in Benzene- d_6 .

[00158] Alkylation of 2,3-Butanedione (2,6-Diisopropylphenyl)(n-Octyl)Bis-Imine



[00159] General procedure: In a dry box charge 2,3-Butanedione (2,6-Diisopropylphenyl)(n-Octyl)Bis-Imine (2.8 mmol, 1.0g) to a 25 mL 2-neck flask equipped with a stir bar and septa. The reaction vessel was sealed, removed from dry box and place under Nitrogen. Toluene (10.0 mL) was added. The vessel was chilled to 0°C. Trimethylaluminum (28.0 mmol, 14.0ml, [2.0M solution in hexanes]) was added dropwise. The reaction was allowed to slowly warm to room temperature and stir. After 6 days the reaction mixture was hydrolyzed with NaOH/H₂O, transferred to a separatory funnel and extracted with toluene. The extracts were combined and vacuum stripped to a clear, red-brown liquid residue. The product was confirmed by ¹H NMR in Benzene-d₆.

[00160] Reaction of the Amine-derived Alkylation product of 2,3-Butanedione (2,6-Diisopropylphenyl)(n-Octyl)Bis-Imine with Tetrabenzylzirconium



[00161] General procedure: In dry the box Tetrabenzyl zirconium (0.200mmol, 0.091g) was charged to a 7 mL amber bottle equipped with a stir bar and cap. Benzene-d₆ (1.5 mL) was added and stirred to dissolve. To a vial was charged the isomeric 80:20 mixture of Amines-derived alkylation products of 2,3-butanedione (2,6-diisopropylphenyl)(n-octyl)Bis-imine with trimethylaluminum (0.200 mmol, 0.074 g) and 1.5 mL Benzene-d₆. The ligand solution was transferred into the tetrabenzyl zirconium solution. The reaction was allowed to stir at room temperature overnight then analyzed by ¹H-NMR.

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MMAO Cocatalyst, 0.5 micromoles MMAO/Zr = 1,000

Activity	I2	I21	MFR	BBF
1,882	-	-	-	-

Conditions: 85°C, 85 psi ethylene, 43 mL hexene, no hydrogen.

The results teach that a non-sterically bulky amide complex (major component on the left) does not lead to significant polymerization activity. Greater steric bulk is required for the amide functionality.

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